

## **AMENDMENTS TO THE SPECIFICATION**

Please replace paragraph [0031] with the following new paragraph [0031]:

[0031] FIG. 1 illustrates a bead portion 10 of a cured tire in accordance with the present invention. The carcass ply 12 is formed by cords 14 that are oriented radially in the sidewalls. The carcass cords 14 are wound continuously between a first radially inward end and at least a radially outer location. One method of cord placement and how the cords may be placed in the tire ~~is are~~ disclosed in commonly assigned U.S. patent application "An Improved Method and Apparatus for Manufacturing Carcass Plies for a Tire," Serial No. 10/365,374, filed February 11, 2003; and ~~commonly assigned U.S. patent application,~~ "Method for Manufacturing Tires on a Flexible Manufacturing System," Serial No. 10/365,374, also filed February 11, 2003.